

# Work Order ID 70323

Thursday, June 02, 2011 2:47:39 PM

Page 1

Item ID: D3204-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 6/8/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

I-Turn D3204-7 bushing as per Folio FA355 and Dwg D3204LJ2-Deburr

20 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 11/7/6

20 0

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SA 11/07/06

20 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3204-7

Accept

Revision ID:

Item Name: Bushing

Start Date: 6/8/2011 Start Qty: 20.00

Required Date: 6/17/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 41

0.00



Packaging

Memo

0.00

Packaging

11/7/16

20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/16 JF  
MF  
11-07-06-

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 02, 2011 2:47:36 PM

Page 1

Work Order ID: 70323

Parent Item: D3204-7

Parent Item Name: Bushing




Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B:04.06.09: Change Step 6; remove Steps 7 & 8: KJ/RF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500  303 Round Bar 0.500"		Purchased		No		100	f	46.2000	0.0358	0.753684		11/7/16	

Location

MAT028

117143

Loc Qty

46.2

46.2

Loc Code

7124

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**NOTE:** Date & initial all entries

70324

☒ **First Article**      ☐ **Prototype**

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/17/16	Date:	11/17/16	Date:	N/A

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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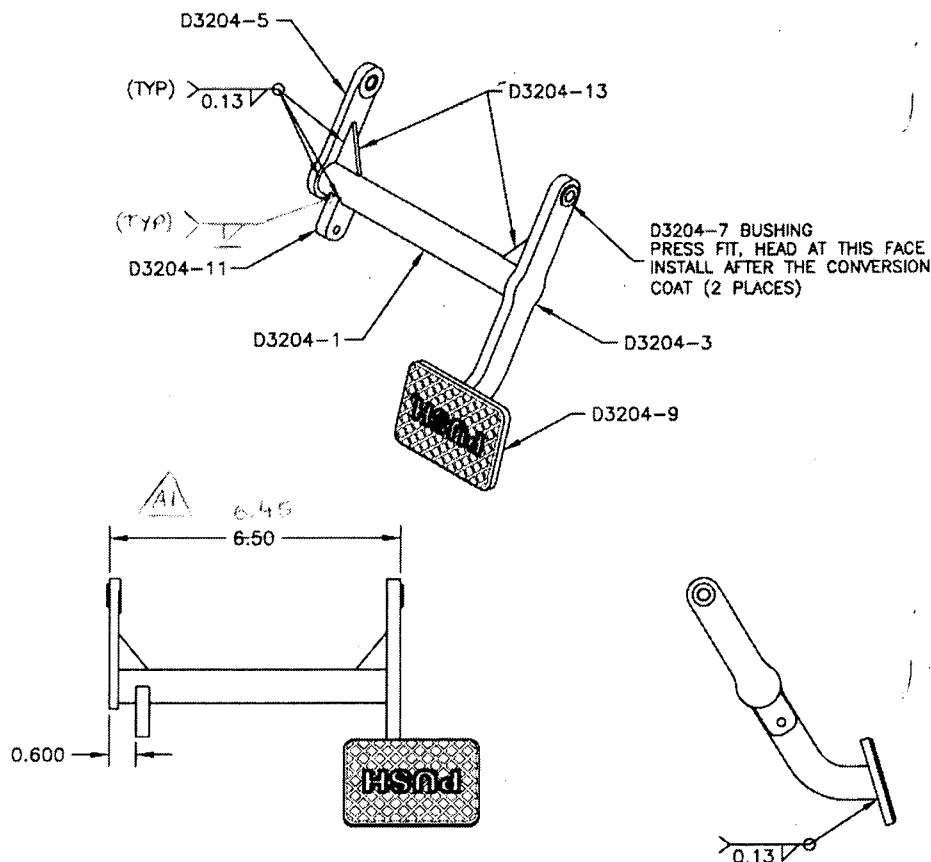
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DESIGN F		DRAWN BY F		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H		APPROVED H		DRAWING NO. D3204	
				REV. A SHEET 1 OF 3	
DATE 04.01.27			TITLE RELEASE PEDAL ASSEMBLY		
			SCALE NTS		
A		04.01.27		NEW ISSUE	
AI		05.07.15		6.45 WAS 6.50	

RELEASED  
04.04.30



### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

20328

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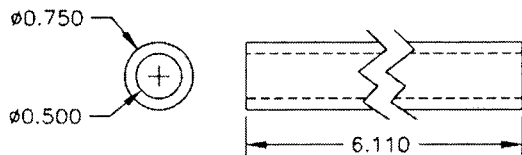
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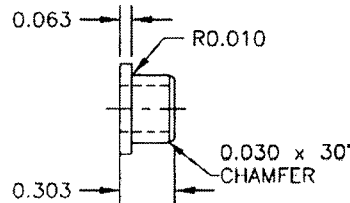


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

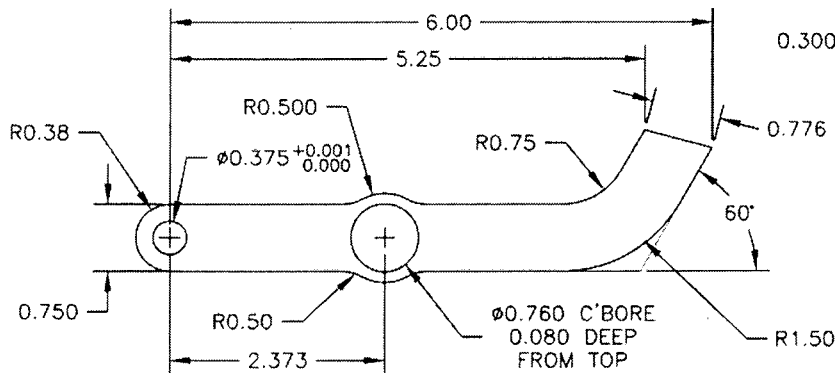
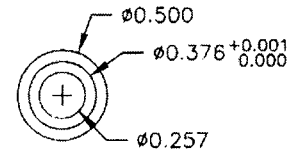
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04.04.05



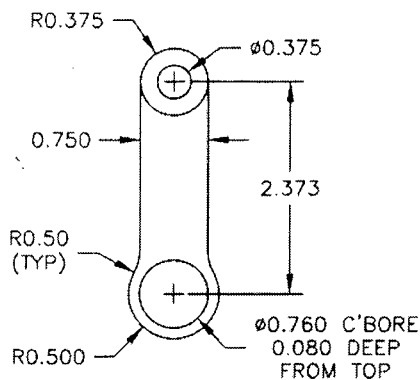
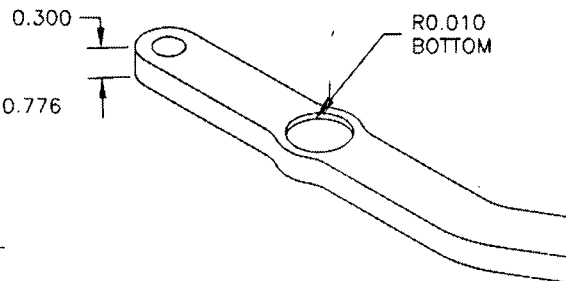
2 D3204-1 TUBE  
SCALE 1:2



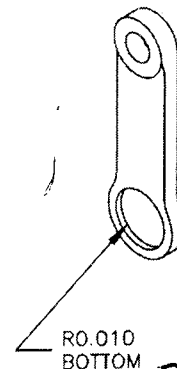
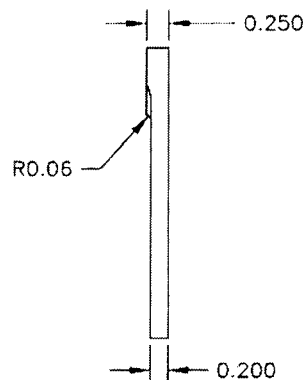
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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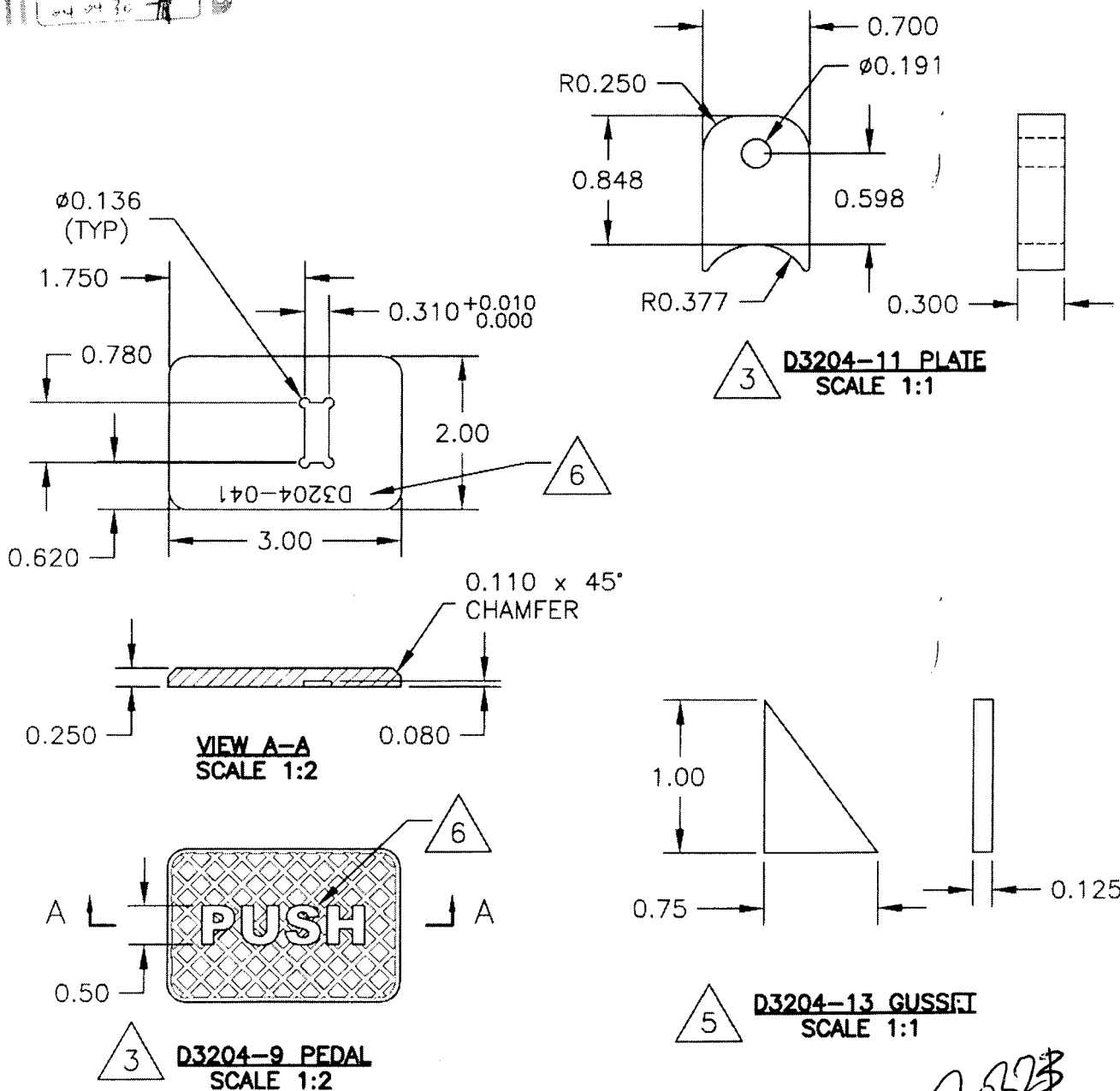
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CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04.04.30



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